



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2667-2

Job Sheet 208467



Part No: D2667-2

Job Qty: 4 pcs *4 pcs 9ml*

Part Name: Saddle, RH, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 8 pcs	4/13/20		1.00	7.98	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/17
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 8 pcs	4/13/20		0.00	7.98	Conventional Mill - 1 - B4B		SBL 20/04/17
							Conventional Mill - 2 - B4B		
120	QC 2	4 8 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S271149



Part: D2667-2

Job No: 208467

Serial No/Batch: S271149

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/16/20

				QC 2 - 57	SBL 20/6/17				
				QC 2 - 62					
				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 2 - 73					
				QC 2 - 69					
				QC 2 - 76					
				QC 2 - 86					
				130 QC 8	42 pcs	4/13/20	0.00 0.00	QC 8 - 12	
								QC 8 - 14	
								QC 8 - 17	
								QC 8 - 20	
QC 8 - 25									
QC 8 - 3									
QC 8 - 32									
QC 8 - 33									
QC 8 - 35									
QC 8 - 39									
QC 8 - 4									
QC 8 - 44									
QC 8 - 45									
QC 8 - 49									
QC 8 - 58									
QC 8 - 8									
QC 8 - 9									
QC 8 - 68									
QC 8 - 67									
QC 8 - 1 (A)									
QC 8 - 47									
QC 8 - 40									
QC 8 - 52									
QC 8 - 23	V48 20/4/18								
QC 8 - 57									
QC 8 - 76									
QC 8 - 61									
QC 8 - 66									
140 Handfinish - 1-1 Chemical-B4B	48 pcs	4/13/20	0.00 0.24	Handfinish - 1 - 1 - B4B	BE820-04-20				
				Handfinish - 1 - 2 - B4B					
				Handfinish - 1 - 3 - B4B					
				Handfinish - 1 - 4 - B4B					
				Handfinish - 1 - 5 - B4B					
				Handfinish - 1 - 6 - B4B					
				Handfinish - 1 - 7 - B4B					
				Handfinish - 1 - 8 - B4B					
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B					
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 - B4B					
				Handfinish - 1 - 18 - B4B					
				Plex 3/20/20 10:15 AM Dart.lajeunesse.marie					

				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	48 pcs	4/13/20	0.00 0.10	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	48 pcs	4/13/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
170	Packaging 3-1 - Stock - B4B	48 pcs	4/13/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 37 - B4B

180 QC 21 - SA	3 pcs	4/13/20	0.00 0.00	QC 21 - SA - 21	APR 21 2020
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 9-86

Part Op 100 - (HAAS CNC Vertical Machine)
 Descriptions: 110 - (Manufacture as per dwg)
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 3 pcs (1 ea)	100-HAAS 4 Axis	5261 891

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	34	36	0

Part Specifications
Specifications could not be found.

Plex 3/20/20 10:15 AM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 208467	
Description: 206 Saddle, Outboard, Right side				Part Number: D2667-2	
Inspection Dwg: D2667 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120	.120	.119	
B	0.100	0.140		.122	.123	.122	.123	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		.660	.660	.660	.660	
E	0.240	0.260		.250	.251	.251	.251	
F	1.313	1.343		1.323	1.322	1.322	1.322	
G	0.210	0.230		.221	.221	.221	.220	
H	0.100	0.180		.132	.132	.132	.132	
I	2.470	2.510		2.493	2.494	2.494	2.494	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		.238	.239	.239	.239	
L	0.100	0.120		.110	.110	.110	.110	
M	0.990	1.010		1.005	1.005	1.006	1.006	
N	0.510	0.515		.511	.511	.511	.511	
O	5.990	6.010		6.002	6.002	6.002	6.002	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		.312	.312	.312	.311	
S	0.315	0.322		.316	.316	.316	.316	
T	1.995	2.005		2.000	2.000	2.000	2.000	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.794	.795	.794	.795	
W	1.040	1.060		1.049	1.049	1.049	1.049	
X	1.674	1.679		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.258	.258	.258	.258	
Z	0.912	0.932		.923	.922	.924	.922	
AA	0.490	0.510		.501	.502	.499	.500	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: SBC	Date: 20/04/17
Audited by: [Signature]	Date: 20/4/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					